



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

*containing 4
5096435*
RBE350A93-3317-20
Job Sheet 173863-A



S/N 5096435

Part No: RBE350A93-3317-20

Job Qty: 3 ea

Part Name: Tail Rotor Hub Insert Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 7/26/18

Job Tracking No:

Due Date: 7/19/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RBE350A93-3317-20 REV: 1B IPP REV: A 18.01.15 NEW ISSUE RQ VERIFIED BY: DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	QC	3 pcs		7/19/18	0.00	0.00	QC2		
140	QC	3 pcs		7/19/18	0.00	0.00	QC8 Machining-2		
170	Outsource	3 pcs		7/19/18			GRO002-VC <i>Meter</i>	10	<i>CT18-7-26</i>
180	Packaging	3 pcs		7/19/18	0.00	0.00	Packaging2		<i>DAS 07/27/18</i>
185	QC	3 pcs		7/19/18	0.00	0.00	QC6		<i>38</i>
190	Packaging	3 pcs		7/19/18	0.00	0.00	Packaging3		<i>DAS 9-88 MLC</i>
210	QC21-FG	3 Ea		7/19/18	0.00	0.00	QC21		<i>21 JUL 27 2018</i>

Part Op 170 - Issue P/O to Groupe Attech; PO *040617* -Black oxide finish, MIL-C-13924C Class 1 *9-88* Certificate of
Descriptions: Conformity is required *Meter*
180 - Receive

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 7/26/18 12:51 PM dart.lacelle.linda

7/19/2018

[Dart Hawkesbury] Job Sheet - David, Logan



Dart Aerospace Ltd.
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Tel (613) 632-5200

RBE350A93-3317-20
Job Sheet 173863



Part No: RBE350A93-3317-20

Job Qty: 24 ea

Part Name: Tail Rotor Hub Insert Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 3/8/18

Job Tracking No:

Due Date: 7/19/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A93-3317-20 REV: 1B IPP REV: A 18.01.15 NEW ISSUE RQ VERIFIED BY: DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea	7/19/18	7/19/18	0.00	0.00	Start Up Machining-4		DAS
120	CNC Lathe	24 pcs	7/19/18	7/19/18	0.00	2.00	MORI SL2500Y		56
130	QC	24 pcs	7/19/18	7/19/18	0.00	0.00	QC2		9-89
140	QC	24 pcs	7/19/18	7/19/18	0.00	0.00	QC8 Machining-2		
170	Outsource	24 pcs	7/19/18	7/19/18			GRO002-VC	10	
180	Packaging	24 pcs	7/19/18	7/19/18	0.00	0.00	Packaging2		
185	QC	24 pcs	7/19/18	7/19/18	0.00	0.00	QC6		
190	Packaging	24 pcs	7/19/18	7/19/18	0.00	0.00	Packaging3		
210	QC21-FG	24 Ea	7/19/18	7/19/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per folio FB742 FOLIO REV: AA DWG REV: 1B 2-Deburr Engrave T/N And /
Descriptions: or S/N number as required Using Marktronic engraver as per DWG.

170 - Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
Conformity is required

180 - Receive

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R2.250	AISI 4140 Q&T Round Bar	7.9200 ft (.33 ea)	90-Start up Operation	5038524

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R2.250	8	18	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 7/19/18 4:31 PM dart.log

Container No: S096435



Part: RBE350A93-3317-20

Job No: 173863

Serial No/Batch: S096435

Revision: 1B

Inspector:

Exp Date:

Instructions:

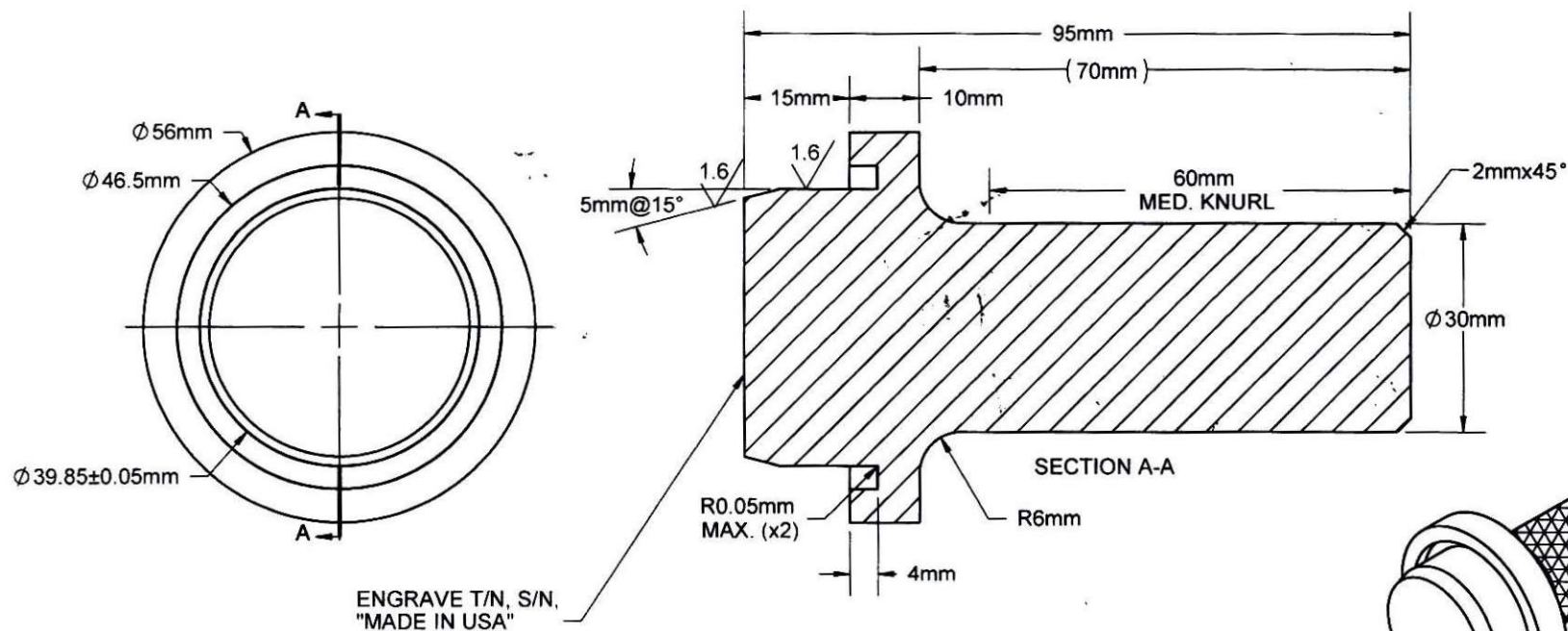
https://w

Date: 07/26/18

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	DESIGNED PER HELI PRODUCTS TOOLS	9/28/09	WP DW
1A	ADDED ENGRAVE NOTE & 70mm REF. DIMENSION.	10/4/11	RJC DW
1B	CH'D T/N WAS RBEA93-3317-20 IS RBE350A93-3317-20.	11/6/13	RJC RW



NOTE:
1. CENTERS OK.

173863
20180719

RED BARN MACHINE	
TITLE TAIL ROTOR HUB INSERT TOOL	
DWG NO. RBE350A93-3317-20	REV 1B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	METRIC ± 0.1 FRACTIONS ± 1/32 ANGLES ± 5°
DRAWN BY PERRITT	
APPROVED	
HEAT TREAT BLACK OXIDE	
FINISH SPEC	
USED ON MODEL EUROCOPTER	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES Ø15 ± .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 9-28-09
SHEET 1 of 1	

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
				1	INSERT TOOL	4140 Q&T	Ø2-1/4 in. x4 in.	-
ASSY #								



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040617**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040617

PO Date: 7/26/18

Due Date: 7/27/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1				Miscellaneous Expense-Purchased Parts	Black Oxide Process (3 parts)	Firmed	71475-180-0000	7/27/18	1 Ea	0 Ea	1 Ea	\$90.00/Ea	\$90.00

Line Item Note As per JL Menard

Grand Total: \$90.00

Order Notes

Plex 7/26/18 2:03 PM dart.lavoie.chantal



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Subcontract Shipping History

Shipper No: *	Part No: *	Sort Method: Ship Date
Status: *	Supplier: *	Ship Date: 7/1/2018 - 7/27/2018
Job No: 173863-a		

Shipper	Supplier	Ship Date	Part No	Container No	Job	Shipped Qty	Returned Qty	% Complete	Sales Tax
483	MEM001-VC	7/27/18	RBE350A93-3317-20	S096671	173863-A	3	3	100.0	DAS 38 9-89
Shipper Total				1		3	3	100.0%	
Grand Total				1		3	3		



METAL TECHNOLOGY INC.

(613) 678-3957 • Fax: (613) 678-3956

20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0 • www.metec.ca • admin@metec.ca

Dart

P0040617

3 parts black oxide

RBE350A93-3317-20

Picked up by Jeanne

July 27, 18

charge 1 hour \$90.00

PO to come



Dart Aerospace Ltd.
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PURCHASE ORDER PO040617

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040617
PO Date: 7/26/18
Due Date: 7/27/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173863-A	RBE350A93- 3317-20	Tail Rotor Hub Insert Tool Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/27/18	1 pcs <i>3</i>	0 pcs	1 pcs	\$1.00/pcs <i>90.00</i>	\$1.00 <i>90.00</i>
Line Item Note As per JL Menard											<i>90.00</i>
Grand Total:											\$1.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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